



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.1814
Job Sheet 168294



Part No: 647.1814

Job Qty: 4 ea

Part Name: Gusset LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/28/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV A SHEET 5 IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/27/17	0.00	0.00	Start Up Container		SC 17/12/23
110	Waterjet	4 pcs		11/27/17	0.00	0.65	Waterjet1		SC 17/12/23
120	QC	4 pcs		11/27/17	0.00	0.00	QC2		SC 17/12/23
130	QC	4 pcs		11/27/17	0.00	0.00	QC8		38
140	Brake NC	4 pcs		11/27/17	0.00	0.46	Brake NC 1		DAS 2-88
150	QC	4 pcs		11/27/17	0.00	0.00	QC5		38
160	Outsource	4 pcs		11/27/17	0.00	0.00	Outsource4		9-88
170	Packaging	4 pcs		11/27/17	0.00	0.00	Packaging2		CT 18-6-28
180	QC	4 pcs		11/27/17	0.00	0.00	QC5		38
190	SprayPaint	4 pcs		11/28/17	0.00	0.45	Spray Paint		9-88
200	QC	4 pcs		11/28/17	0.00	0.00	QC14		38
210	Packaging	4 pcs		11/28/17	0.00	0.00	Packaging3		JUL 24 2018
220	QC21-SA	4 Ea		11/28/17	0.00	0.00	QC21		DAS JUL 24 2018

Part Op 110 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 160 - ISSUE P/C 040356 HARD ANODIZE, COLOR BLACK AS PER DWG. (SEE NOTE 2)

190 - PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2) CARDINAL 4860-50 PRIMER BATCH: _____

210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.040	0	236	0	0
	138389	0.4			

Part Specifications

Specifications could not be found.

Plex 11/14/17 7:46 AM dart.boucher.sylvie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																														
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Date : _____ S026912 Gusset LH	IOTY Effective : Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																														
PART NO: 647.1814 Revision: Operation: Start up Operation Change No:		Mfg Date: 12/23/17 Job No: 168294																																																																
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OTHER : _____																																																																		

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03686				SHEET 1 OF 2	
	DWG NO. 647.1800	REV: N/C	PREPARED BY B. PETERS	DATE: 11/12/12	EFFECT ON DWG ☒ INC. ☐ UNINC.	
	DWG TITLE: SHEETMETAL					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED RADIUS ON SHEETMETAL BEND.				ECR: D-12-020	

NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
- 1 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120

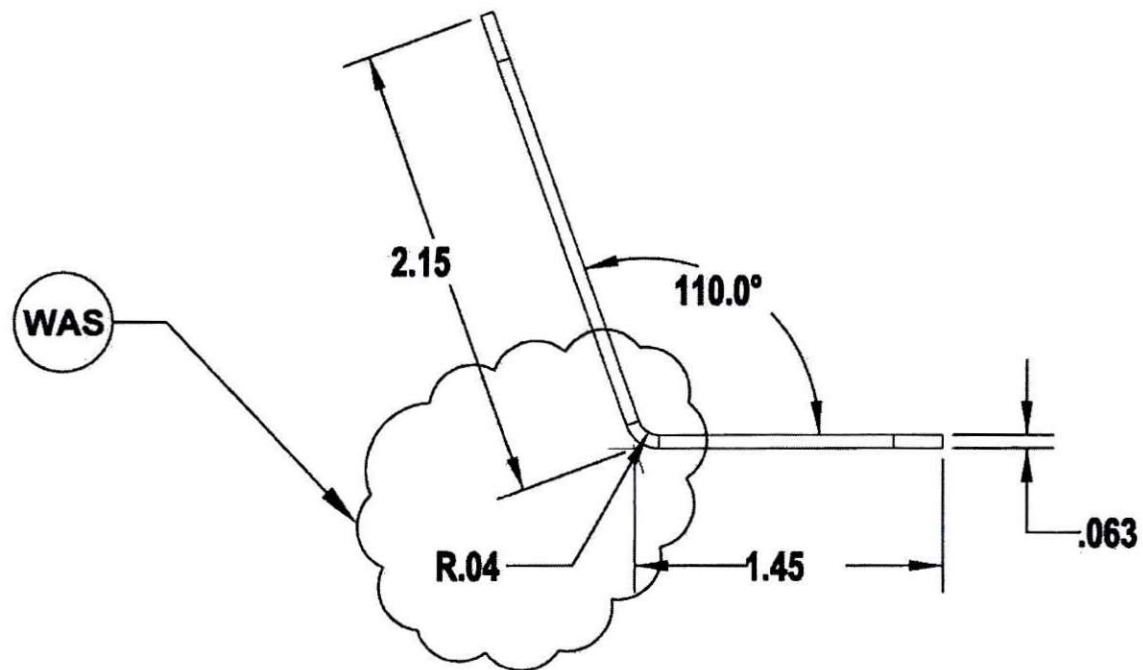
SHEET 1, ZONE A1 WAS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *168294*

DAS
30
9-89

NOV 16 2017

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				☐ RFMS ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO



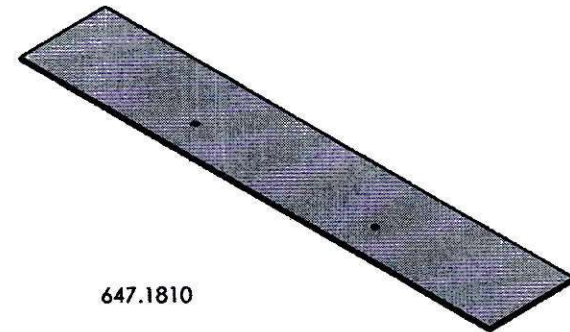
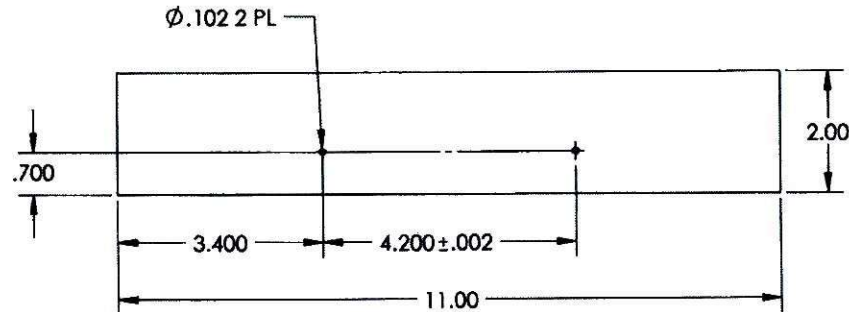
SHEET 4, ZONE D5 WAS:

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: P02		REC
INC	INITIAL RELEASE	06/01/09	P. BRAVO
A	INCORPORATED ECN 0366	11/12/13	P. BRAVO

NOTES:

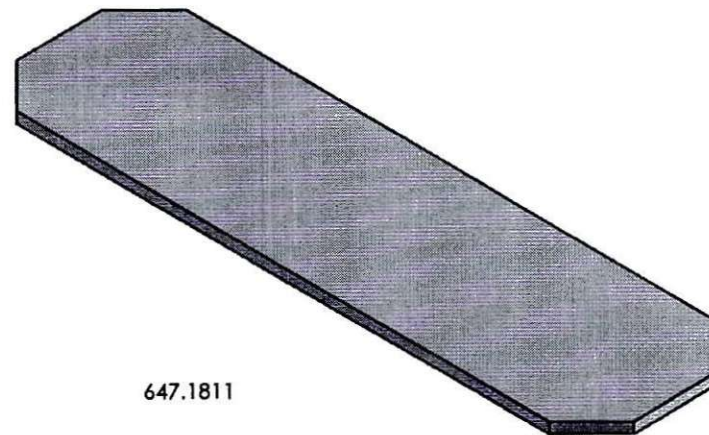
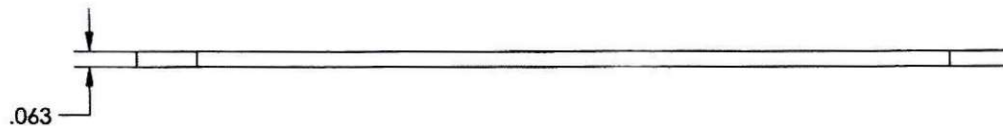
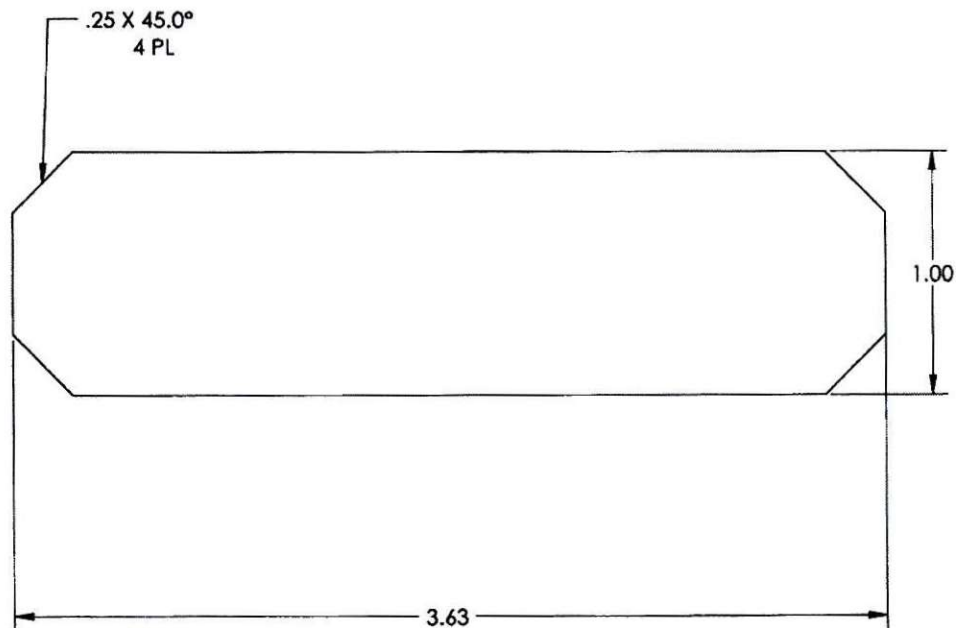
1. PRIMARY MATERIAL: 2024-T3 ALUMINUM PER AMS-QQ-A-250/4
ALTERNATE MATERIAL: 6061-T6/T62 ALUMINUM PER AMS-QQ-A-250/11
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



647.1810

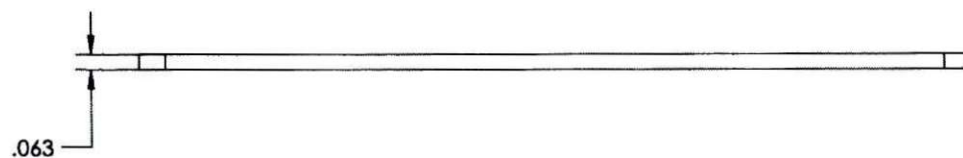
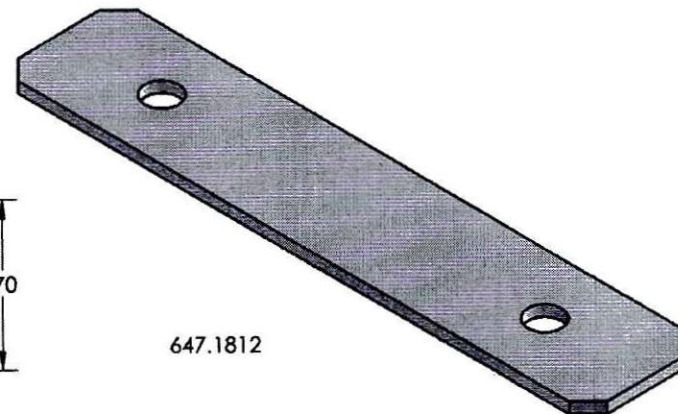
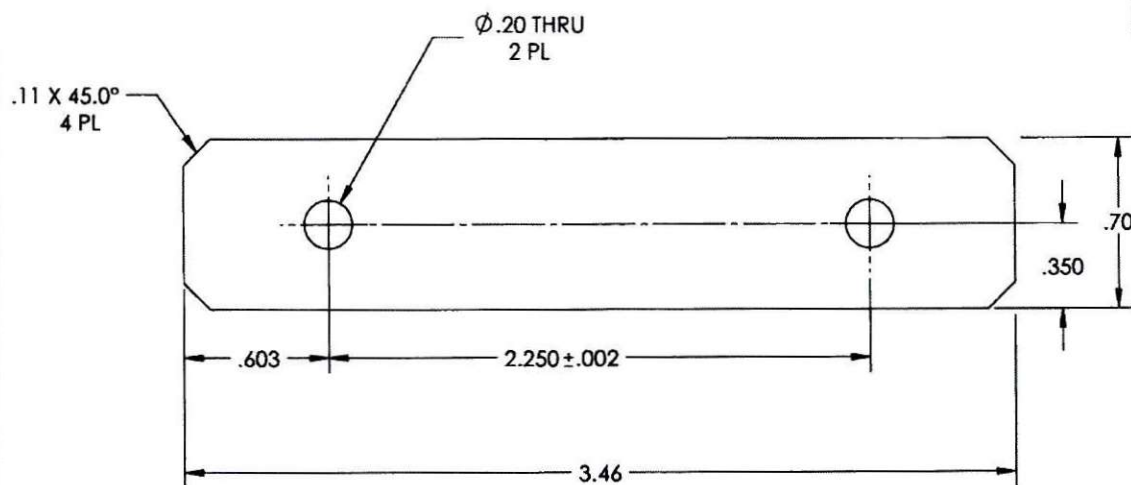
		647.1818	NOSE DOOR SPACER	△	△
		647.1817	SUPPORT, RH	△	△
		647.1816	SUPPORT, LH	△	△
		647.1815	GUSSET, RH	△	△
		647.1814	GUSSET, LH	△	△
		647.1813	ANGLE	△	△
		647.1812	SHIM	△	△
		647.1811	SPACER	△	△
		647.1810	NOSE DOOR DOUBLER	△	△
	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY			PARTS LIST		
NEXT ASSY (S)			APICAL INDUSTRIES		
647.1300			2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300		
			SHEETMETAL		
ORIGINAL DATE 08-01-09 DRAWN BY SCHWENK I. LOHMEYER P. BRAVO DRAWING APPROVAL 08-01-09 CONTRACT NO.			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		
			SIZE	CAGE CODE	DWG NO.
			B	071426	647.1800
			SCALE NONE		REV. A
			SHEET 1 OF 7		

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ORIGINAL DATE REV-DWG-101 06-01-89		APICAL INDUSTRIES	
DRAWN BY J. GARDNER		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY P. BRAY		SHEETMETAL	
DRAWING APPROVAL P. BRAY		REV. A	
DESIGNED BY CONTRACT NO.		SCALE: NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS .01 3 PLACE DECIMALS .005 ANGLES .5°		SHEET 2 OF 7	

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ORIGINAL DATE (MO-DA-YR) 01-01-02		APICAL INDUSTRIES	
DRAWN BY J. GARDNER	CHECKER J. BRAY	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL J. BRAY	DATE 01-01-02	SHEETMETAL	
CONTRACT NO.		647.1800	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		REV B	REV A
SCALE: NONE		SHEET 3 OF 7	

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.23 X 45.0°
PL

UP 70.0° R .13

(1.42) (2.11)
3.53

FLAT PATTERN

3.63

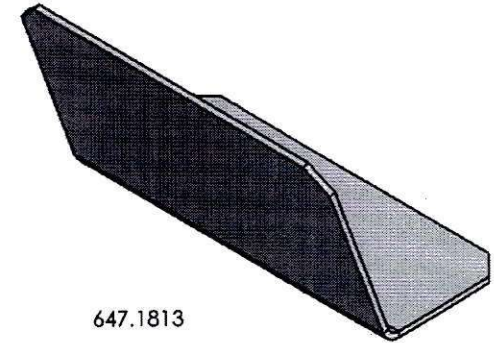
2.15

110.0°

R.125

1.45

.063



647.1813

ORIGINAL DATE:
DESIGN: TEL. 647.1813
DRAWN BY: J. GARDNER
CHECKED: P. BRAVO
DRAWING APPROVAL:
P. BRAVO
CONTRACT NO.:

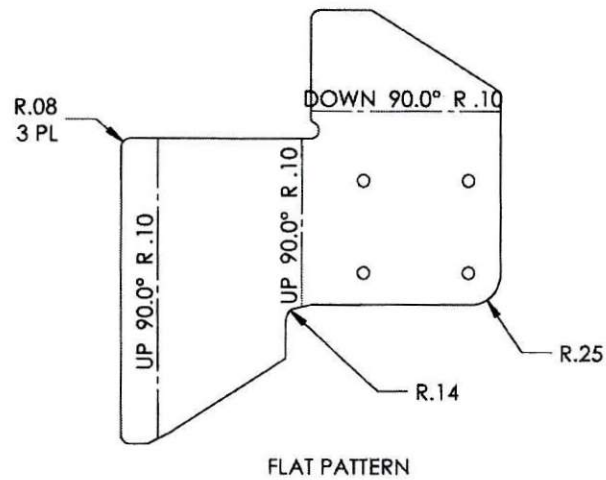
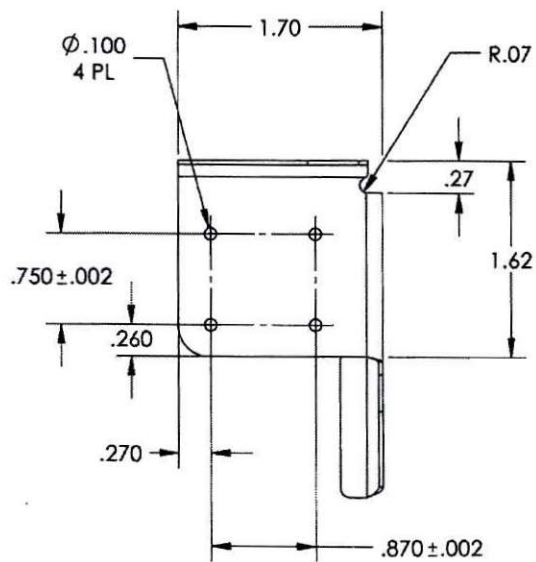
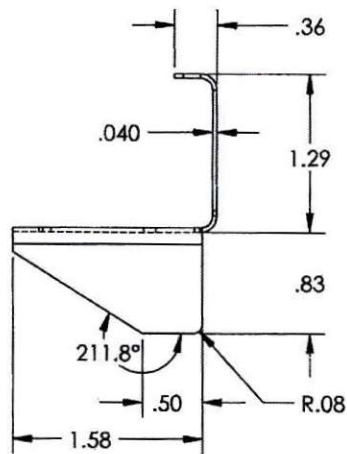
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.002
ANGLES ± 5°

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

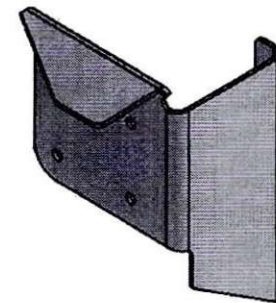
SHEETMETAL

SIZE	CAGE CODE	DWG. NO.	REV.
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SCALE: NONE			SHEET 4 OF 7

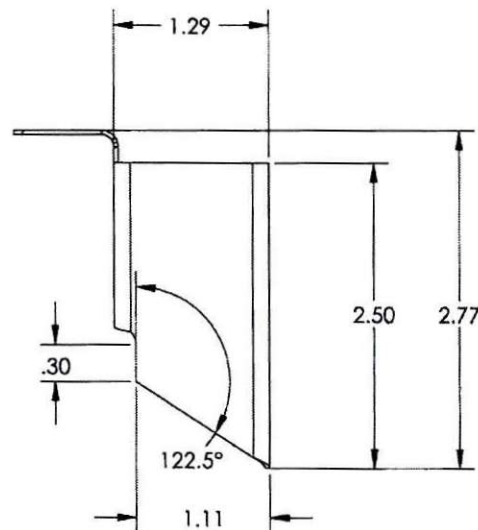
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FLAT PATTERN

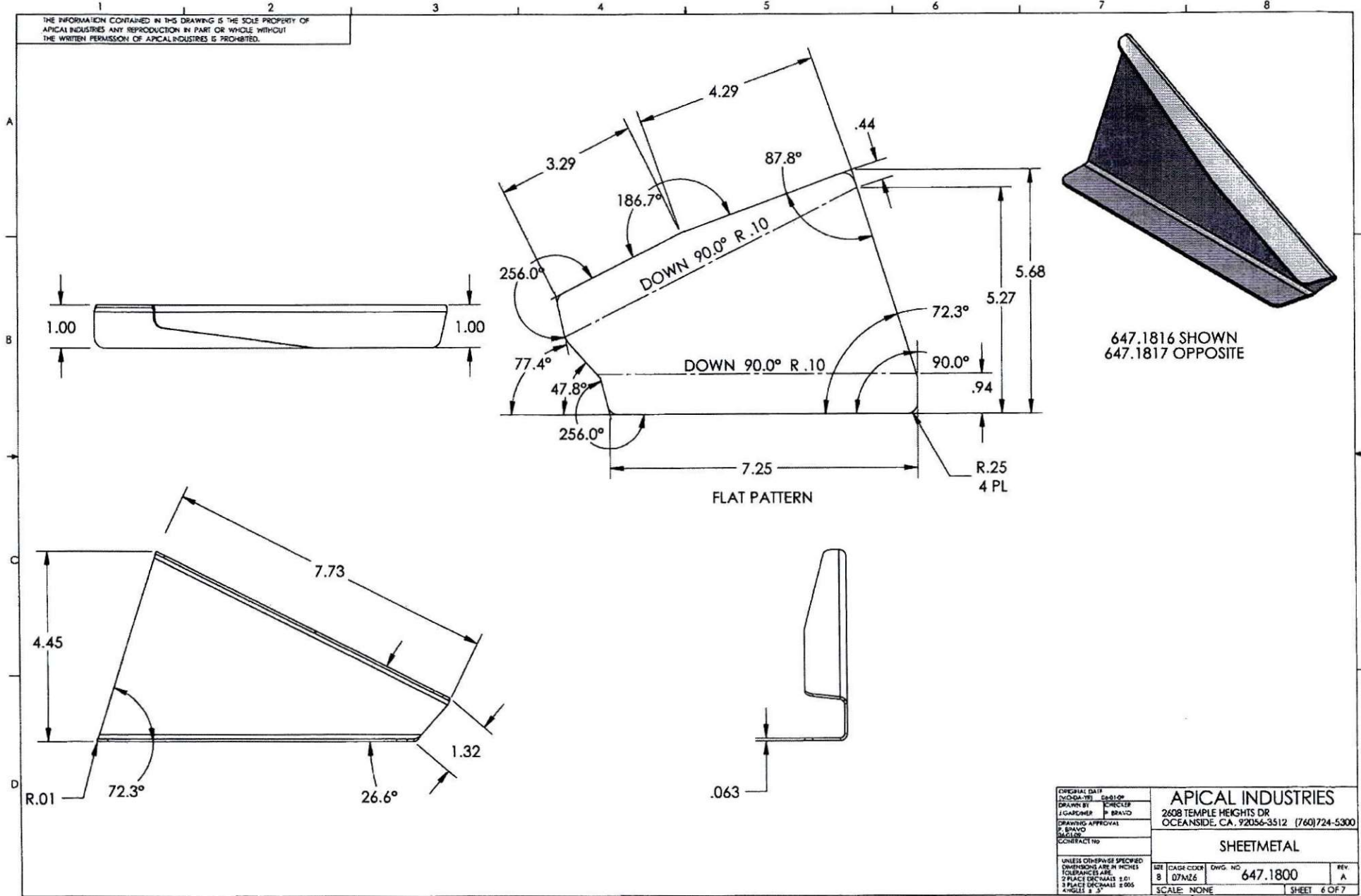


647.1814 SHOWN
647.1815 OPPOSITE



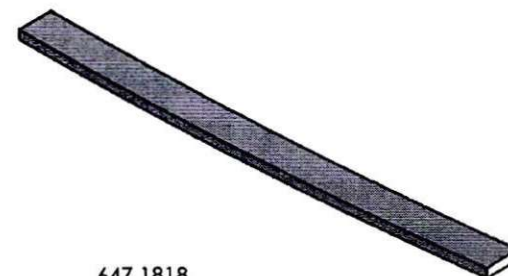
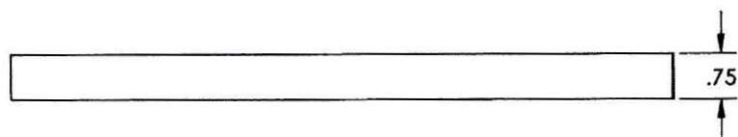
ORIGINAL DATE: 06/01/09		APICAL INDUSTRIES	
DESIGNED BY: J. GARDNER		2608 TEMPLE HEIGHTS DR.	
DRAWN BY: P. BRAYO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
CHECKED BY: P. BRAYO		SHEETMETAL	
APPROVED BY: P. BRAYO		SEE CASH CODE	
CONTRACT NO.:		DWG NO. 647.1800	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE: 2 PLACE DECIMALS ±.01, 3 PLACE DECIMALS ±.005, ANGLES ±.1°		REV. A	
		SCALE: NONE	
		SHEET 5 OF 7	

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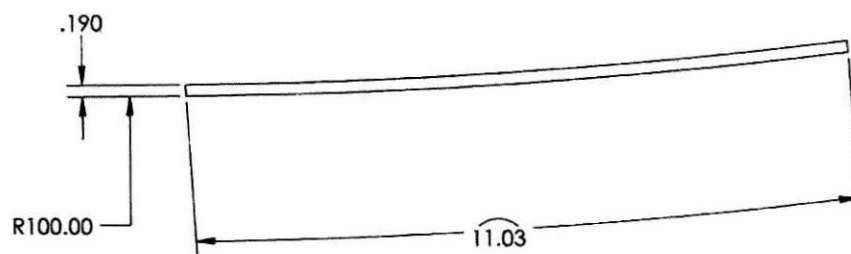


APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR OCEANSIDE, CA. 92056-3512 (760)724-5300	
SHEETMETAL	
SPECIAL DATA 1/20/04-101 DRAWN BY: J. GARDNER CHECKED BY: P. BRAVO DRAWING APPROVAL: P. BRAVO DATE: 10/10/04 CONTRACT NO:	SIZE: 8 CAGE CODE: 07M26 DWG. NO: 647.1800 SCALE: NONE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°	REV: A SHEET 6 OF 7

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647.1818



ORIGINAL DATE (MM/DD/YY) 06-01-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
DRAWN BY J. GARDNER	CHECKED BY P. BRAVO				
DRAWING APPROVAL P. BRAVO					
CONTRACT NO.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE 8	CAGE CODE 07M26	DWG. NO. 647.1800	REV A
SCALE: NONE		SHEET 7 OF 7			

